












Date: Tuesday, 23/09/2008 10:22:31 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG ASSEMBLY
<b>Job Number</b> : 42232	
<b>Estimate Number</b> : 11744	
<b>P.O. Number</b> :	<b>Part Number</b> : D3394041
<b>This Issue</b> : 23/09/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3394 R4EV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 37345	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/10/2008 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLO 08.9.23</u>	
<b>Comment</b> : Est Rev: A New Issue 06-01-06 JLM	
<b>Additional Product</b>	
Job Number: 	
<b>Seq. #:</b>	<b>Machine Or Operation:</b>
<b>Description :</b>	
1.0 D2423	Lug Extrusion
	
<b>Comment:</b> Qty.: 0 f(s)/Unit Total : 3 f(s) D2423 Lug Extrusion Batch: <u>333310</u> <u>C208/09/23</u> (3FT)	
2.0 BAND SAW	BAND SAW
	
<b>Comment:</b> BAND SAW Cut Blank to .850" <u>at @ meter</u>	
3.0 OUTSIDE SERVICE	OUTSIDE SERVICES
	
<b>Comment:</b> Sub-Contracting OUTSIDE SERVICES Send Blanks To: Metec/Mast Precision Machining P/O: <u>7232</u> <u>C208/09/23</u> (40) Machine D3394-1 as per Dwg D3394	
4.0 PACKAGING 1	PACKAGING RESOURCE #1
	
<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage <u>P 8/10/06</u> (40)	
5.0 QC6	DIMENSIONAL CHECK
	
<b>Comment:</b> DIMENSIONAL CHECK <u>508/10/02</u> (40) <u>counters</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:31 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 42232

Part Number: D3394041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB

08-10-02

(40)

7.0

POWDER COATING

POWDER COATING



M109152



(40X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50  
320°F  
8:20

M-L 08/10/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-03

(40X)

9.0

MS3548993

GROMMET



Comment: Qty.: 2 Each(s)/Unit Total: 80 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS35489-93	Grommet	M106168

M106168

08/10/03 (40)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

08/10/06 (40)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/06 (40)

60 units

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST473

08/10/06 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:31 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 42232

Part Number: D3394041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*cf*

*u 08/10/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

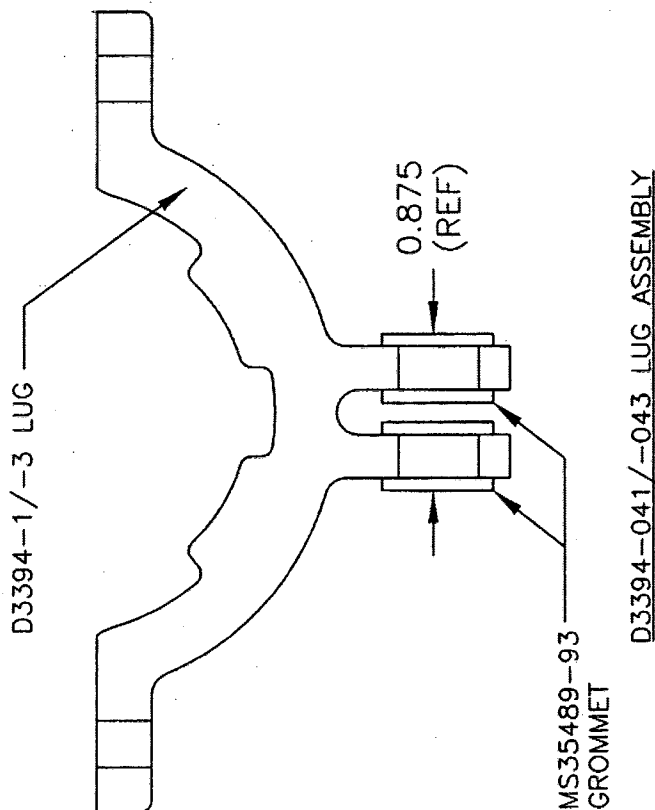
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	



**PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *42232*

RELEASED

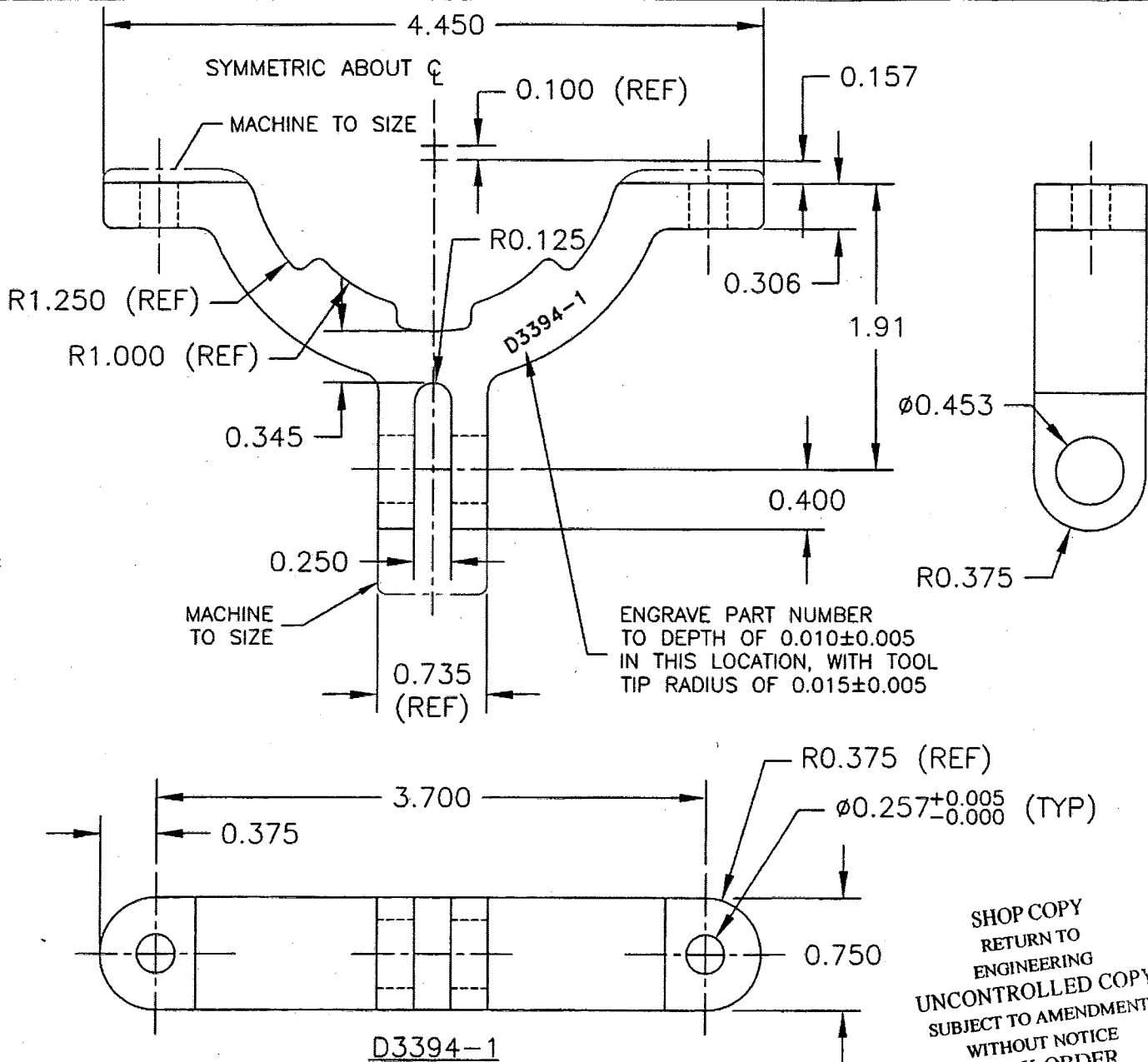
05.11.14

Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42232

**RELEASED**

05-11-14 [Signature]

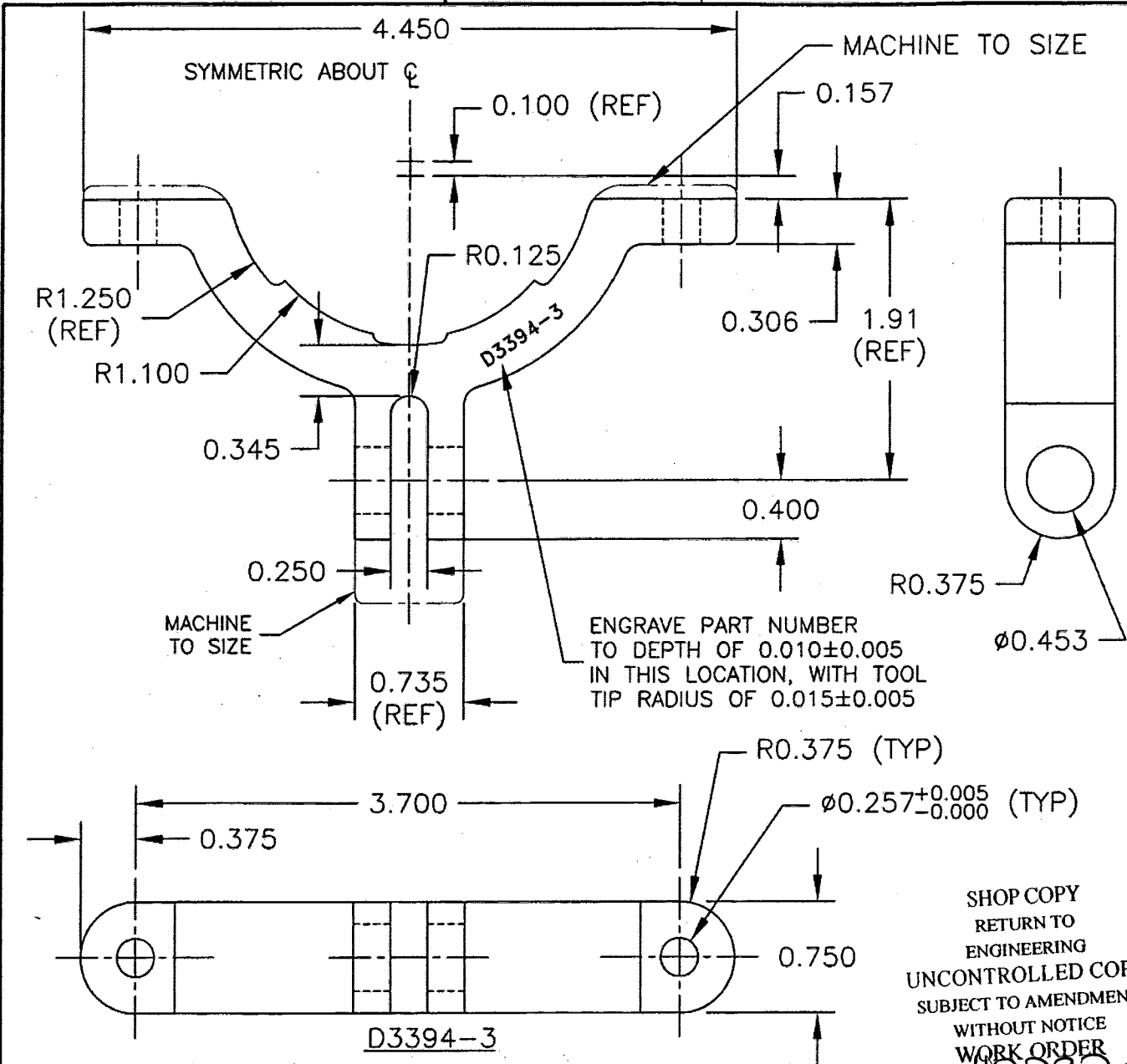
**Copyright © 2005 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
PH	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>[Signature]</i>	<i>[Signature]</i>	D3394	SHEET 3 OF 3
DATE	TITLE	SCALE	
05.02.14	LUG	1:1	

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

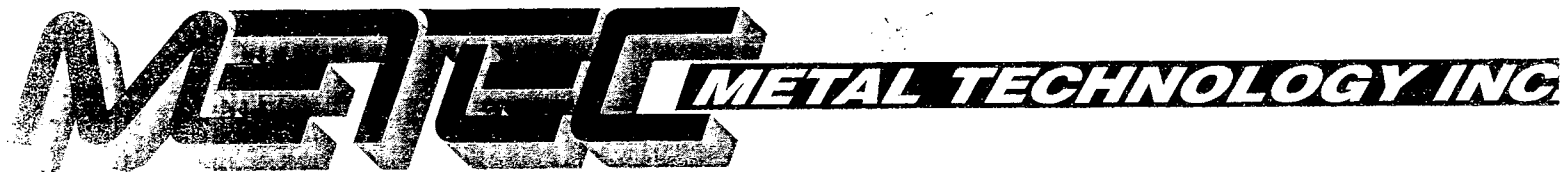
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *42232*

**RELEASED**

05.11.14

**Copyright © 2005 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

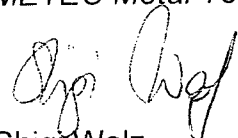
same


<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	<del>D3394-1</del> D3394-1	Lug 42232	7232

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

  
08/10/02

Vankleek Hill, September 30, 2008